

5/13

DART AEROSPACE LTD	Work Order:	22514 A
Description: Bracket Assembly	Part Number:	D2803-042
Dwg: D2803 Rev. B	Qty:	5 <del>20</del> Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	CH	05.02.23	20
2	GA	Press D2805-2 into arm as per Dwg D2803 Pick: Qty Part Number Description Batch	SB	05/03/28	20 S
		1 D2803-2 Bracket B 22524A B 22524B			
		1 D2805-2 Stop B L2 521			
		1 D2809 Bushing B 22529			
3	QC5	Inspect work to Step 2	2	05.03.28	20 S
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ML	05.03.29	20 S
5	QC3	Inspect Powder Coat	SB	05/07/29	5
6	GA	Press D2809 into arm as per Dwg D2803	SB	05/03/30	5
7	GA	Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803 Pick: Qty Part Number Description Batch	SB	05/03/30	5
		2 AN3C16A Bolt M 170 46			
		2 MS21042L3 Nut (or -3) M 16 941			
		4 NAS1515H3 Washer M 16 941			
		A/R LPS-3 Corrosion Spray M 16 863			
8	GA	Assemble as per Dwg D2803.	SB	05/03/30	5
9	QC5	Inspect work to Step 8	2	05.03.30	5
10	ST	Identify and Stock	SB	05/03/30	5
11	AC	Cost / part: <u>81.07</u>	SB	05.04.01	5
12	DC	Close W/O <u>81.07</u> Inspect Level 21	CH	05.04.05	5

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	<i>JLM</i>

RELEASED  
2023-02-23

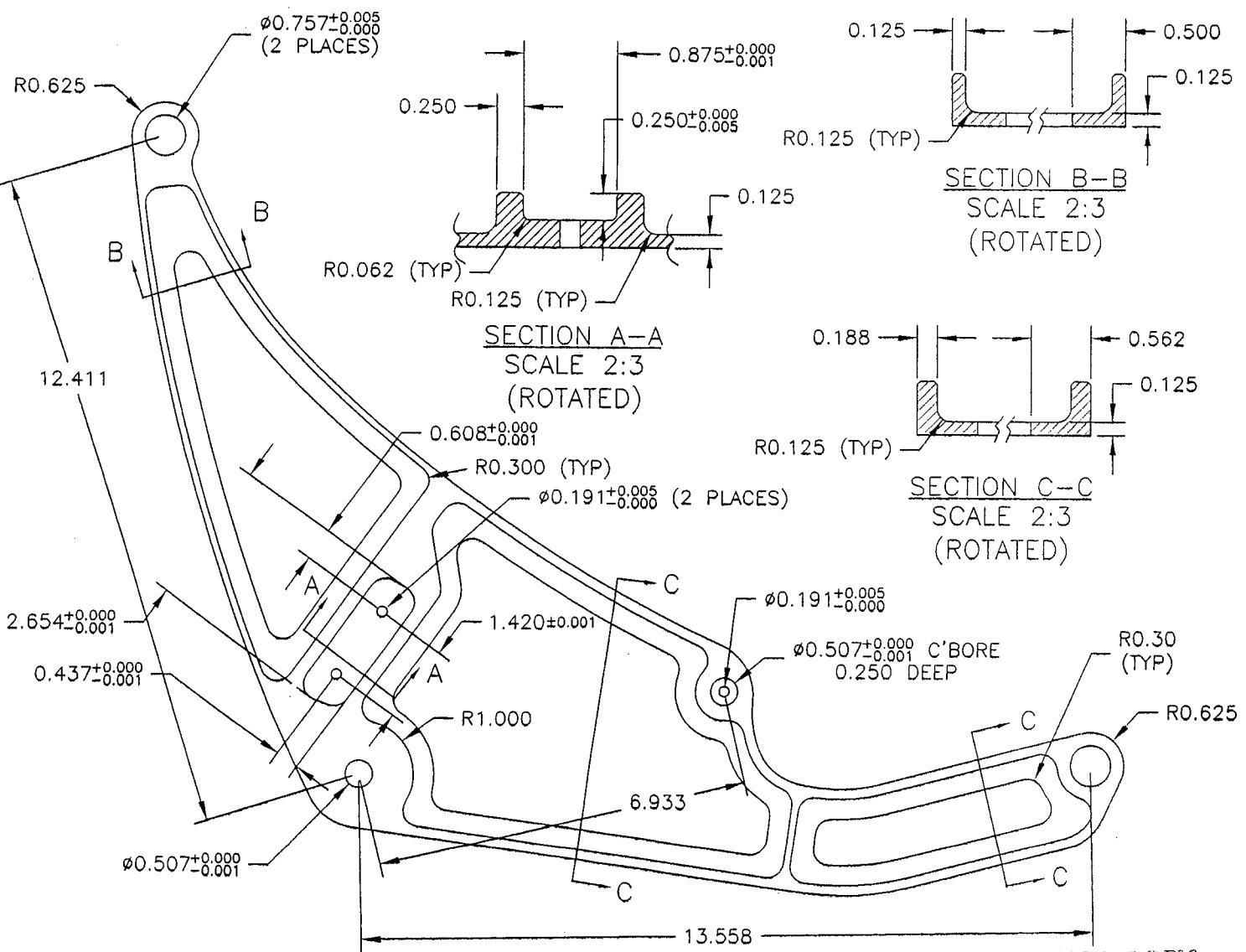
**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2803
DATE 04.11.22		REV. B SHEET 1 OF 2
		TITLE STA 84 BRACKET SCALE 1:3

RELEASED

05.03.11 *[initials]*

A	00.11.07	NEW ISSUE
B	04.11.22	ADD CUTOUTS & -043/-044



D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

NO. 22514

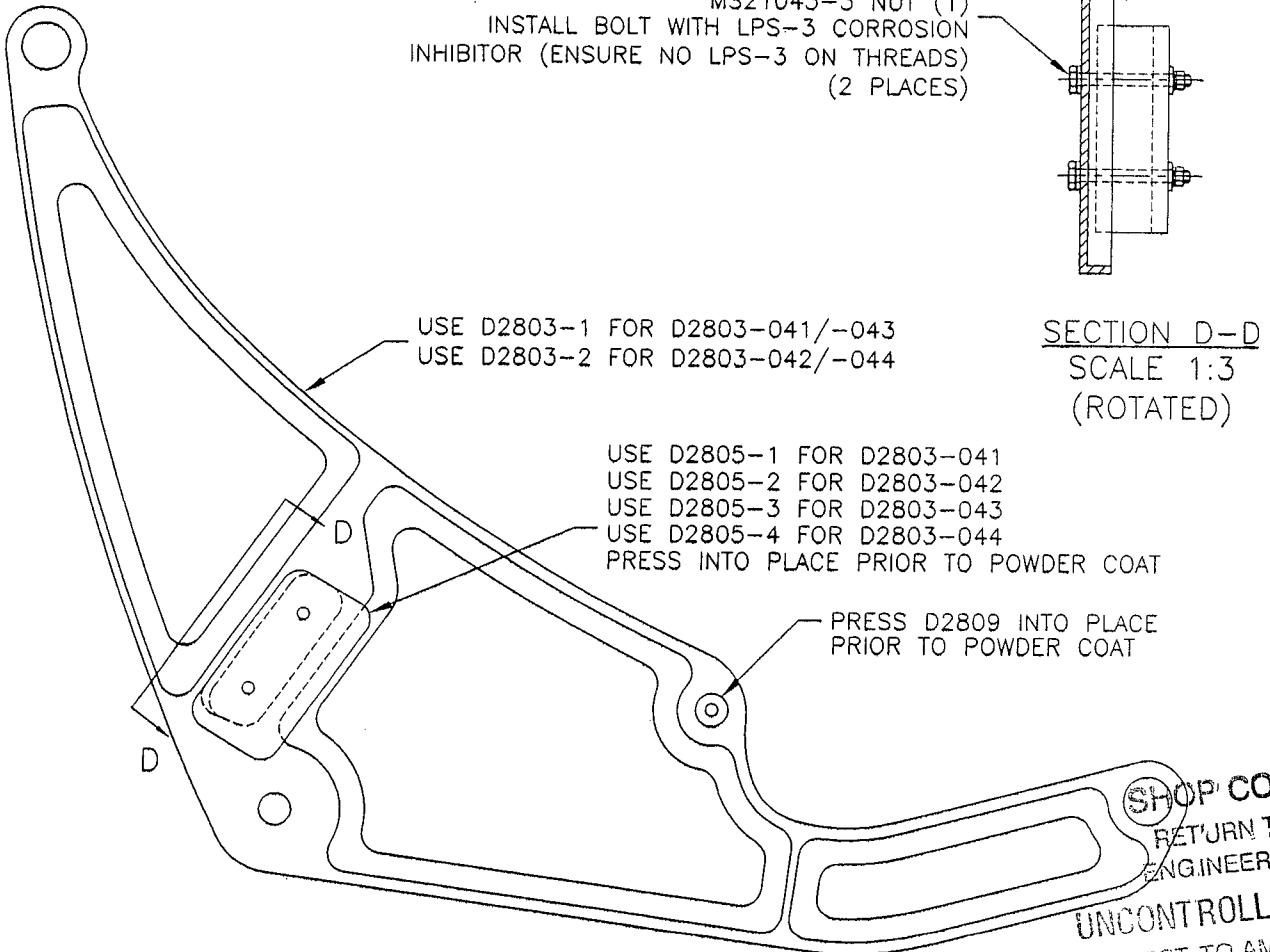
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803
DATE 04.11.22	TITLE	SCALE 1:3

REV. B  
SHEET 2 OF 2



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WORK ORDER

RELEASED *22514*  
05-03-11 *[Signature]*

D2803-041/-043 BRACKET ASS'Y (SHOWN)

D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

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Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 22, 2005  
03:39 pm

Work Order No : 0022514  
 Project Name : D2803-042  
 Project For : WK513  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2803-042  
 Description : Bracket Assembly  
 Manufactured : Yes  
 Amount Req'd : 20  
 Amount Done : 0  
 Start Date : 02-22-05  
 Est Finish Date : 03-15-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00